

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By 		
							Lead hand / Supervisor Approval Verification 		
							QC / QA Coordinator Approval 		

Root Cause				FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence		
☐ OTHER : _____							

Work Order ID 156432

Friday, January 27, 2017 1:21:06 PM

156432

Page 2

Item ID: D4975-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 2/10/2017

Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/15/2017

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Bend as per dwg

0.01

130

Brake NC

Memo

0.01

DAS
30
9-89

FEB 23 2017

Brake NC

140

QC6- Inspect dimensions to drawing

0.00

140

QC

Memo

0.00

DAS
38
9-89

2

FEB 24 2017

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.01

201702/27

Hand Finishing

BEB

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process						
Misidentified ☐	☐ Past Due	☐ OTHER :					

Work Order ID 156432

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156432

Page 3

Item ID: D4975-1**Revision ID:****Item Name:** Bracket**Start Date:** 2/10/2017**Required Date:** 2/15/2017**Reference:****Accept*****N900040100*****Setup Start*****NS1*****Stop*****NS2*****Start Qty:** 2.00***2*****Cust Item ID:****Req'd Qty:** 2.00***2*****Customer:****Approvals:****Process Plan:****Date:****Tooling:****Date:****QC:****Date:****SPC (Y/N):****Date:****Run Start*****NR1*****Stop*****NR2*****Sequence ID/
Work Center ID**

160

160

QC

Quality Control

**Operation
Description**

QC7-Inspect Chemical Conversion Coat

**Set Up/
Run Hours**

0.00

Tool ID**Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

2

DAS

38

9-89

FEB 27 2017

170

170

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

LOCATION: WA003

26

FEB 28 2017

180

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.03

DAS

21

9-89

FEB 28 2017

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Page 1

Work Order ID: 156432

156432

Parent Item: D4975-1

D4975-1

Parent Item Name: Bracket

Start Date: 2/10/2017

Required Date: 2/15/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.06.13 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	192.2100		0.052632			
M6061T6S 063									**				
6061-T6 .063 Sheet													

DAS
46
9-89

17/02/18

Location

Loc Qty

Loc Code

MAT021

192.21

M134604

102.6

M134830

5.11

M136251

84.5

0.054

DQA: _____ Date: _____

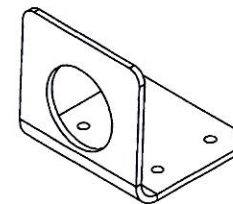
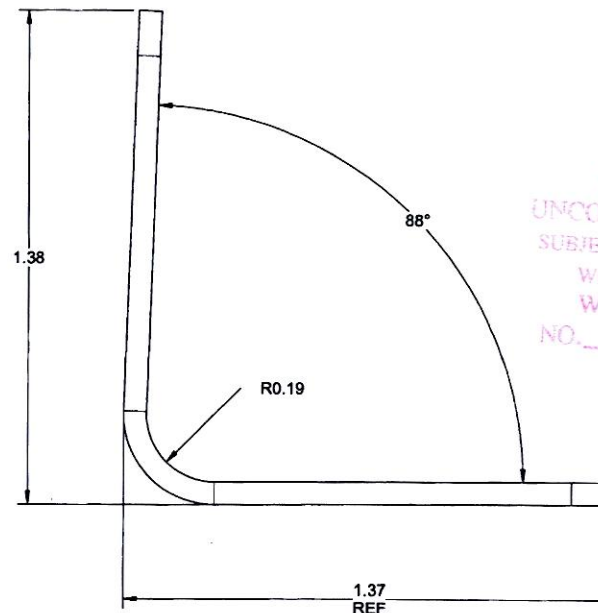
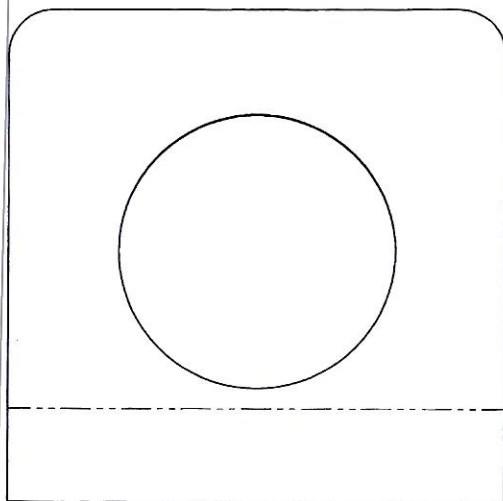


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OTHER : ☐									



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 156432 ML5
170202

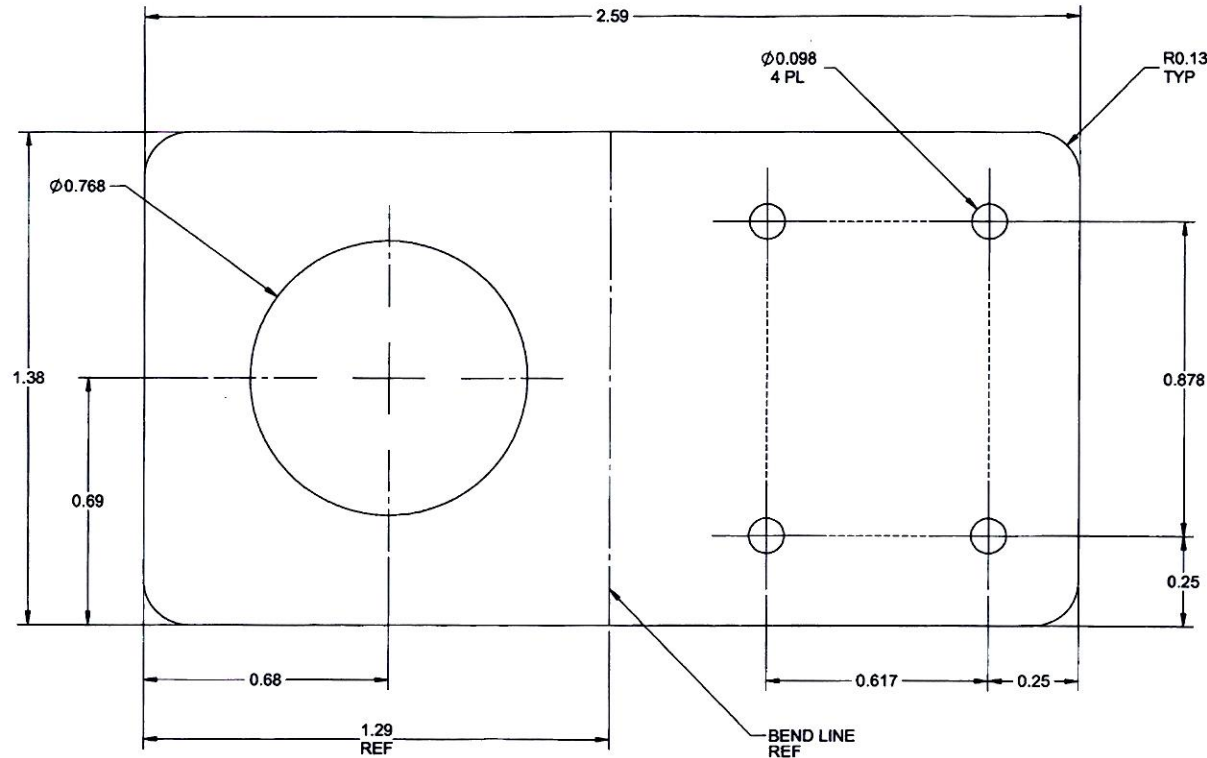
D4975-1 BRACKET
(MAKE FROM D4975-1F)

RELEASED
2014-06-11
mp

- NOTES:**
- 1) MATERIAL: MADE FROM D4975-1F
 - 2) FINISH: APPLY CHEMICAL CONVERSION COATING PER QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

APPROVED	A	NEW RELEASE		ML	13.11.12
	REV.	DESCRIPTION		BY	DATE
	DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	DRAWN	ML			
	CHECKED	AP	DRAWING NO.	REV. A	
	MFG. APPR.	JLM	D4975	SHEET 1 OF 2	
	APPROVED	MP	TITLE	SCALE	
	DE APPR.	DS	BRACKET	NT	
	DATE	13.11.12			
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GRAIN
DIRECTION



D4975-1F FLAT PATTERN

RELEASED
2014-06-11

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4975	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
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